

Work Order ID 75298

October-20-11 9:58:39 AM

75298

Page 1

Item ID: D2989-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Basket Lid Assembly
 Start Date: 20/10/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 08/11/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/20 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D2989 | Rev D | | | | | | | | |

100
100
 Large Fab
 Large Fab
 Large Fab
 Memo
 1- assemble all ribs and both D2581 in DT9445 jig, weld as per dwg D2989
 2- tack weld mesh on basket as per dwg D2989 using DT9445 jig
 ****cut cutouts with zip cut as per dwg D3832****
 3- remove from jig and weld lable plate as per dwg D2989
 A/R ER316 S.S. Rod Batch: 121602
 *** PLEASE NOTE****
 IF MAKING -043A :
 ENSURE 1 X D3836-041 HAS NO BUSHING AND HAS HOLES PER
 DSI9473

CC 12.7.17

110
110
 QC
 Quality Control
 QC9- Insp visual per QSI004- Fusion Welds 0.00
 Memo 0.00

1 12.7.17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries

Work Order ID 75298***75298***

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Item ID: D2989-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Lid Assembly

Start Date: 20/10/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 08/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00

125

HandFinish

Memo

0.00

Hand Finishing

DAS
16
176A17

1 76 12-7-17

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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| | | | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|
| 130 | White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel | 0.00 | | | | | | | |
|-----|---|------|--|--|--|--|--|--|--|

130

Powdercoat

Powder Coating

Memo

0.00

1- Plug holes prior to powder coating

2-Powder Coat White (Ref. 4.3.5.2) D2989-041 as per QSI 005 4.3 & Dwg D2989

1ST COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

***** 2nd coat if necessary *****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

131

Wing Walk as per dwg QSI005 4.4 Batch **121505** 0.00

131

HandFinish

Hand Finishing

Memo

0.00

Mask lid prior to spray paint black and wing walk as per dwg

A/R Spray paint black batch: **128017**

MA 12/07/17

1 p B12-7-18

M121841

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NOTE: Date & initial all entries

75298

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

1

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

140

QC

Memo

0.00

Quality Control

Identify as per dwg & Stock Location: D350-600-043A

141

Packaging

Memo

0.00

Packaging

QC21- Final Inspection - Work Order Release

0.00

150

OC

Memo

0.00

Quality Control

ms 12/07/19

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NOTE: Date & initial all entries

Picklist Print

October-20-11 9:58:45 AM

Page 1

Work Order ID: 75298

75298

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I Removed D2989-043 05-11-03 JLM
IPP Rev:J 08-08-29 revC as per dwg DD verified by:EC
IPP Rev:K 08-09-24 plug hole prior to powder coating DD verified by:EC
IPP Rev:L 08-12-02 revD as per dwg DD verified by:EC IPP rev:M
10.09.14 added pressure wash DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D2221-1

Manufactured

No

100

Each

16.0000

2

2

D2221-1

Rib

**

Location

Loc Qty

Loc Code

WA

16

71372

4

72297

12

D2506

Manufactured

No

100

Each

12.0000

1

1

D2506

Label Plate

**

Location

Loc Qty

Loc Code

WA

12

71087

2

74142

10

D2512-7

Manufactured

No

100

Each

5.0000

1

1

D2512-7

Rib

**

Location

Loc Qty

Loc Code

WA

4

53444

0

71220

4

WA006

1

67445

1

B75

B77522 → ①

| W/O: | | WORK ORDER CHANGES | | | | | |
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Picklist Print

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Page 2

Work Order ID: 75298

75298

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2581 Manufactured No

100 Each 31.0000 2 2

D2581

Mounting Bracket

**

Location

Loc Qty

Loc Code

WA

31

69739

2

70766

2

73079

6

73762

21

386058 → 2

D2989-13 Manufactured No

100 Each 8.0000 2 2

D2989-13

Rib

**

Location

Loc Qty

Loc Code

WA

8

71556

2

72410

6

384604 → 2

D2989-19 Manufactured No

100 Each 8.0000 2 2

D2989-19

Rib

**

Location

Loc Qty

Loc Code

WA

8

71477

2

72411

6

377519 → 2

D3832-3 Manufactured No

100 Each 3.0000 1 1

D3832-3

Mesh (Lid)

**

Location

Loc Qty

Loc Code

WA

3

71301

3

3 63460 → 1

86576

October-20-11 9:58:45 AM

Shop Packet Print

Page 2

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 75298

75298

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3833-3 Manufactured No

100 Each 17.0000 2 2

D3833-3 ✓

Mesh (Lid End)

**

Location

Loc Qty

Loc Code

WA

17

67460

17

D3836-041 Manufactured No

100 Each 3.0000 1 1

D3836-041

Rib Assembly (Basket Lid, LH)

**

Location

Loc Qty

Loc Code

WA

2

72412

2

WA005

1

71746

1

D3836-042 Manufactured No

100 Each 3.0000 1 1

D3836-042

Rib Assembly (Basket Lid, RH)

**

Location

Loc Qty

Loc Code

WA

2

72413

2

WA005

1

71745

1

D3852-041 Manufactured No

100 Each 3.0000 1 1

D3852-041

Rib Assembly

**

Location

Loc Qty

Loc Code

WA

3

70722

3

CPL 12.7.17
~~B67460~~ → ~~②~~ ①
~~B87051~~ → ①

CPL 12.7.11
 B77515 → ①

CPL 12.7.11
 B77514 → ①

CPL 12.7.11
 B86154 → ①

| W/O: | | WORK ORDER CHANGES | | | | | |
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Work Order ID: 75298

75298

Parent Item: D2989-041

D2989-041

Parent Item Name: Basket Lid Assembly

Start Date: 20/10/2011

Required Date: 08/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3852-042

Manufactured No

100

Each

4 0000

1

1

D3852-042

Rib Assembly

**

Location

Loc Qty

Loc Code

WA

4

66089

1

70723

3

PL 12.07.11
B86043 → ①

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

D2989-043 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

D2989-041 BASKET LID ASSEMBLY
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 75298 M.L.O
11/10/20

- NOTES:
1) MATERIAL: N/A
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: D2989-041 = 26.50 lbs; D2989-043 = 15.50 lbs
8) WELD PER DART QSI 004

| ITEM | QTY -041 | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-------------|-----------|---------------------------|
| 1 | X | | D2989-041 | BASKET LID ASSEMBLY |
| 2 | | X | D2989-043 | BASKET LID ASSEMBLY |
| 3 | 1 | | D2506 | LABEL PLATE |
| 4 | 1 | | D2512-7 | RIB |
| 5 | 2 | | D2581 | MOUNTING BRACKET |
| 6 | | 1 | D2989-3 | RIB |
| 7 | | 1 | D2989-4 | RIB |
| 8 | | 2 | D2989-5 | RIB |
| 9 | 2 | | D2989-13 | RIB |
| 10 | 2 | 1 | D2989-17 | RIB |
| 11 | 2 | | D2989 19 | RIB |
| 12 | | 2 | D3182-1 | HINGE |
| 13 | | 2 | D3442-3 | SHIM |
| 14 | | 1 | D3827-041 | RIB ASSY (INBOARD) |
| 15 | 1 | | D3832-3 | MESH, BASKET LID |
| 16 | | 1 | D3832-5 | MESH, BASKET LID |
| 17 | 2 | | D3833-3 | MESH, LID END |
| 18 | | 2 | D3833-5 | MESH, LID END |
| 19 | 1 | | D3836-041 | RIB ASSY (BASKET LID, LH) |
| 20 | 1 | | D3836-042 | RIB ASSY (BASKET LID, RH) |
| 21 | | 1 | D3838-041 | RIB ASSY (BASKET LID, LH) |
| 22 | | 1 | D3838-042 | RIB ASSY (BASKET LID, RH) |
| 23 | 1 | | D3852-041 | RIB ASSEMBLY |
| 24 | 1 | | D3852-042 | RIB ASSEMBLY |

RELEASED
08/11/18

| D | REVISED -041/-043 PARTS LISTS AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); D3836-041 REPLACES D2989-9/-15; D3836-042 REPLACES D2989-10/-15; D3838-041 REPLACES D2989-1/-7; D3838-042 REPLACES D2989-2/-7; D3852-041 REPLACES D2989-11; D3852-042 REPLACES D2989-2, REMOVED D2327-3 (NOW INSTALLED ON D3836 DWG), D2989-9/-10 (NOW ON D3836 DWG), D2989-1/-2/-7/-15 (NOW ON D3838 DWG) AND D2989-11/-12 (NOW ON D3852 DWG). REASON: TO SATISFY "LEAN MANUFACTURING" PROGRAM | MB | 08.09.24 |
|------------|---|-----|----------|
| C | FRAME MATERIAL WAS 0.060 WALL, MESH MATERIAL UPDATED: DRAWING TRANSFERRED TO "B" FORMAT AND CURRENT DRAFTING STANDARD | AJS | 08.06.20 |
| B | ADD SHIM UNDER HINGES, UPDATE LID DIMENSIONS | PH | 05.06.07 |
| A | NEW ISSUE | DS | 00.10.27 |
| REV | DESCRIPTION | BY | DATE |
| DESIGN | DS | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.09.24 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2989** REV. D
TITLE **BASKET LID ASSEMBLY** SCALE NTS

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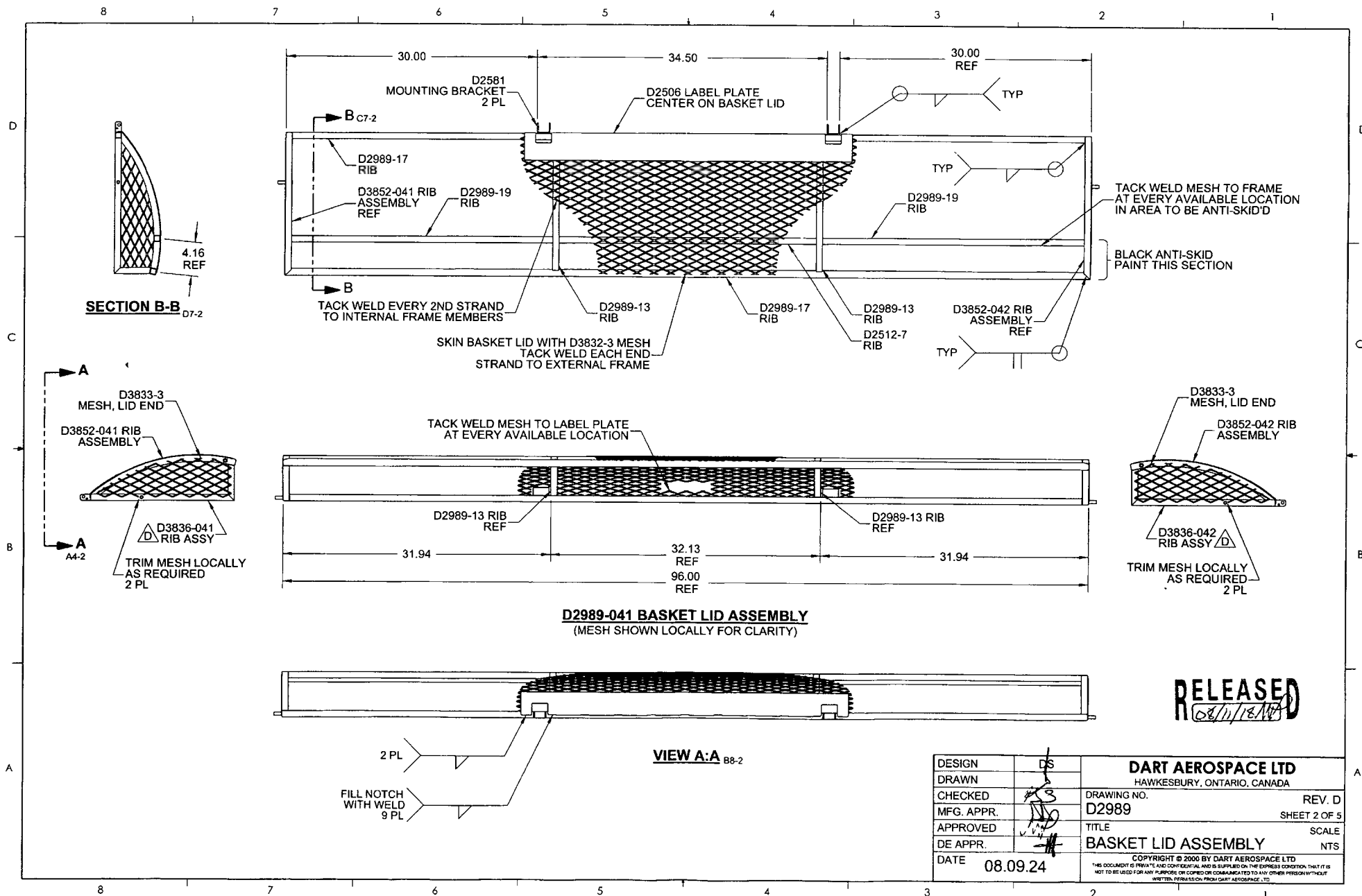
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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|------------|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | DS | DRAWING NO. | REV. D |
| MFG. APPR. | DS | D2989 | SHEET 2 OF 5 |
| APPROVED | DS | TITLE | SCALE |
| DE APPR. | DS | BASKET LID ASSEMBLY | NTS |
| DATE | 08.09.24 | <small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small> | |

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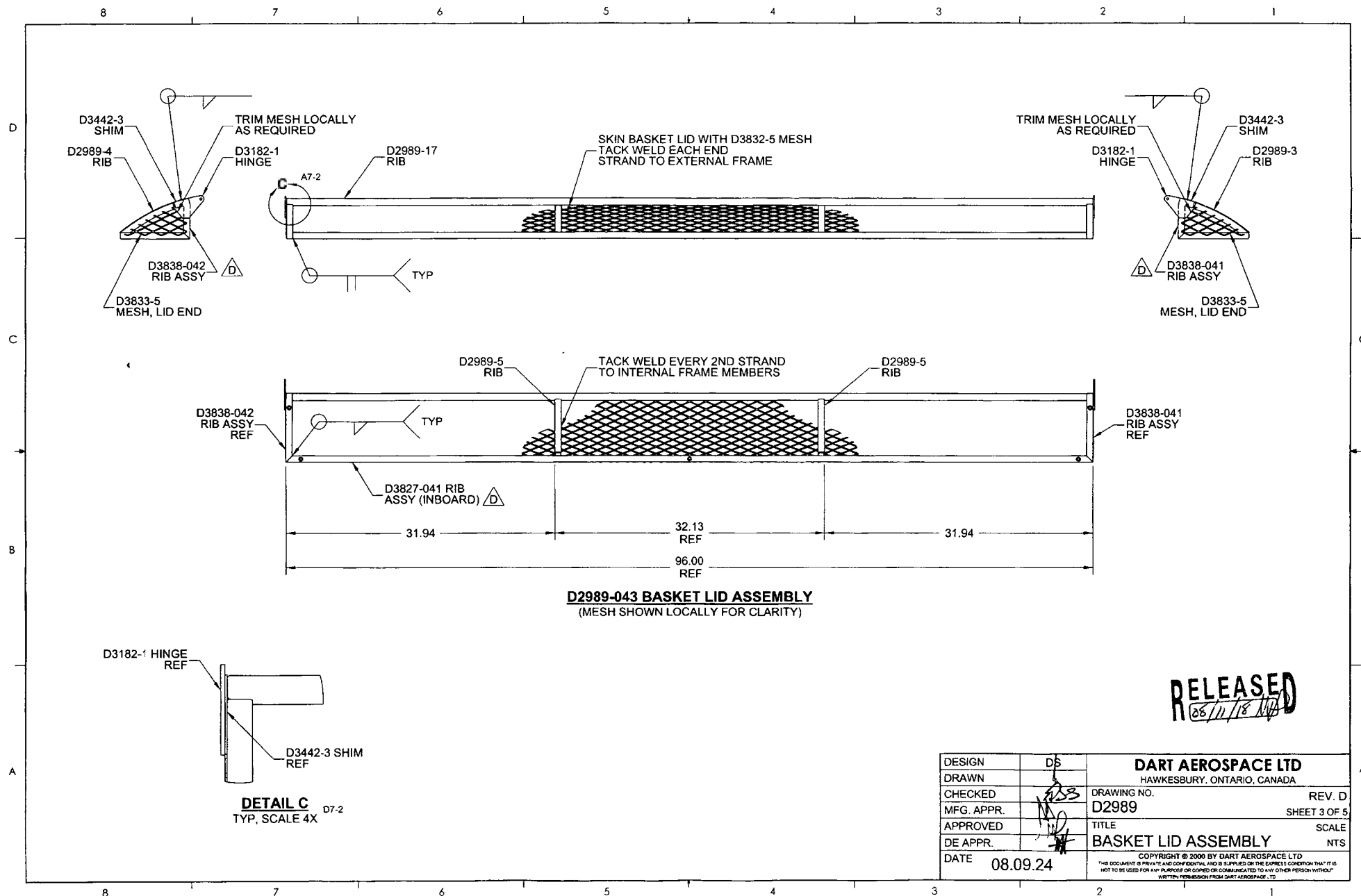
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NOTE: Date & initial all entries

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08/11/18

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| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D2989 | SHEET 3 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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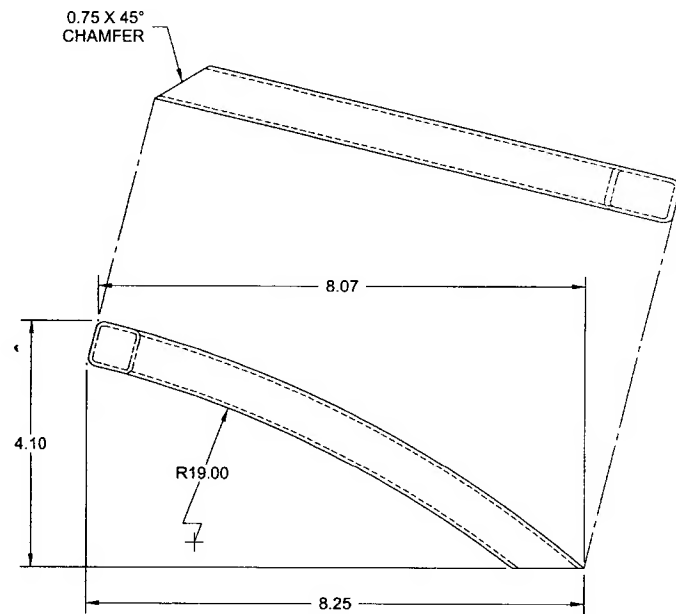
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

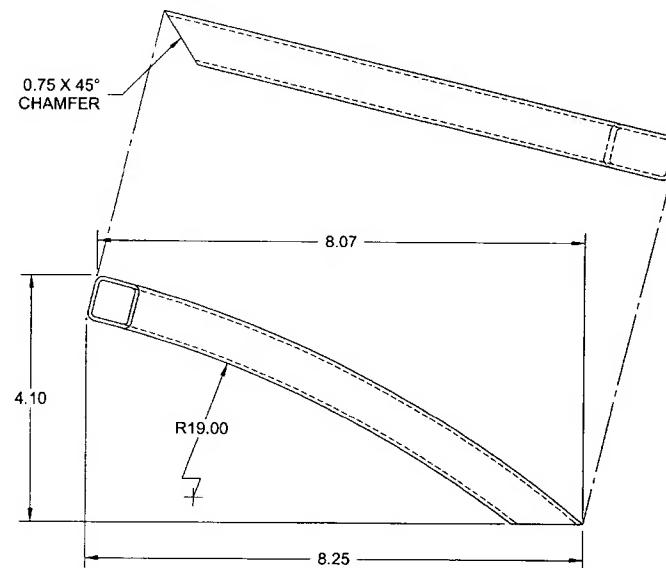
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

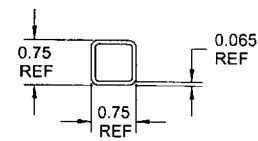
75298



D2989-3 RIB



D2989-4 RIB



TYPICAL SECTION VIEW

- NOTES:
- 1) MATERIAL: D3166-3 BASKET HOOP
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2989-3/-4 = 0.39 lbs;

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| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D2989 | SHEET 4 OF 5 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BASKET LID ASSEMBLY | NTS |
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|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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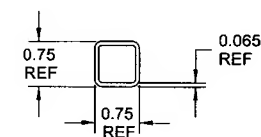
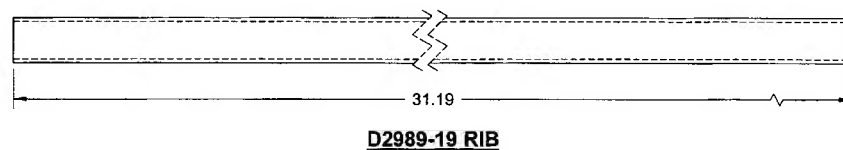
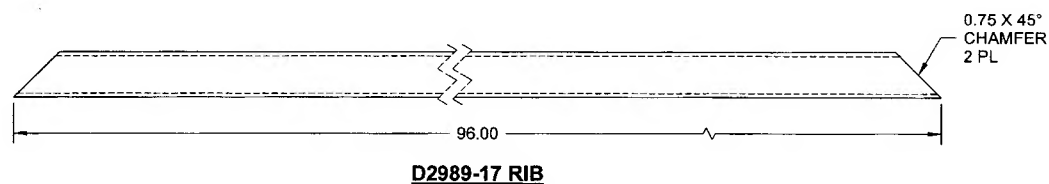
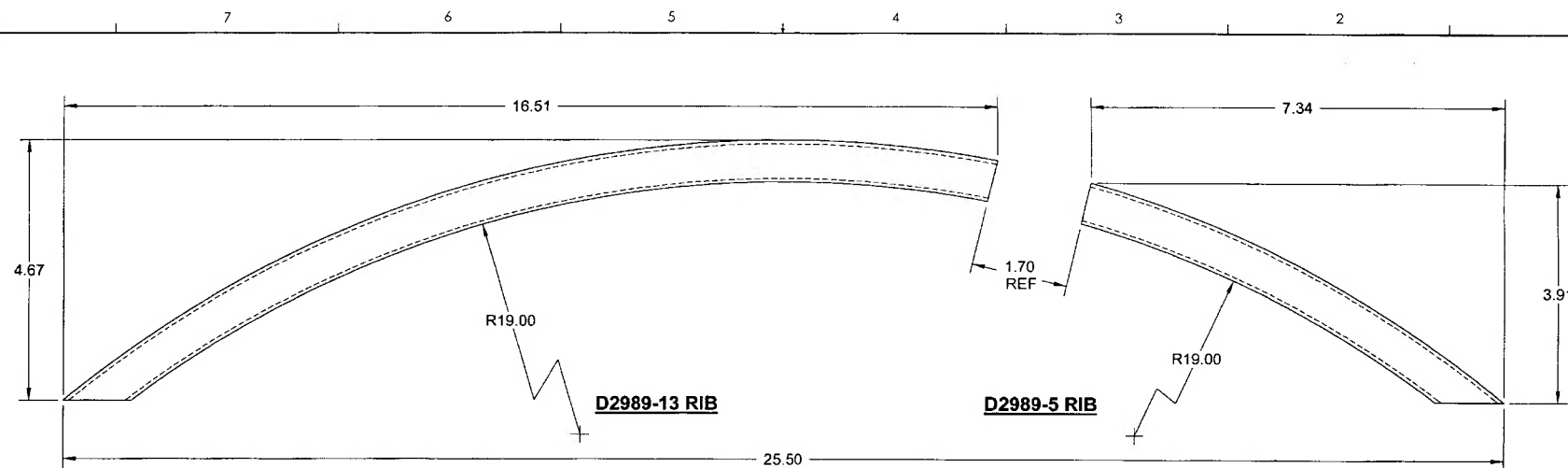
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

75298



NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2989-5 = 0.37 lbs; D2989-13 = 0.81 lbs; D2989-17 = 4.57 lbs; D2989-19 = 1.50 lbs

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| DESIGN | DS | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | SS | DRAWING NO. | REV. D |
| MFG. APPR. | | D2989 | SHEET 5 OF 5 |
| APPROVED | | TITLE | SCALE |
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| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries